

Work Order ID 81472

Wednesday, March 14, 2012 2:25:06 PM

81472

Page 1

Item ID: D4149-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Lug Assembly, Aft
Start Date: 3/14/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/6/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: MC Date: 12-03-14 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4149	C								

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: 468

0.00

120

Packaging

Memo

0.00

Packaging

EP 12/04/05 (6)

(46)

12/4/15 (6) SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/4/5
12-04-5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, March 14, 2012 2:25:05 PM

Page 1

Work Order ID: 81472

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 3/14/2012

Required Date: 4/6/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
DD verf:JLM

IPP Rev:C 11.03.03 as per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3 Nut		Purchased	No			100	Each	836.0000	4	12		3/12/04/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		72							
				103691		72							
				GA		334							
				120693		334				12			
				ST301		430							
				118077		2							
				118614		378							
				118686		30							
				119758		20. #							
MS21043-4 Nut		Purchased	No			100	Each	1,193.0000	1	18		3/12/04/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		40							
				104603		40							
				ST301		1153							
				119546		415				18			
				120308		738							
D3910-1 Crosstube Lug		Manufactured	No			100	Each	15.0000	1	6		3/12/04/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st507		15							
				78326		15							

B81474
(62)

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 81472

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 3/14/2012

Required Date: 4/6/2012

Start Qty: 6.00

Required Qty: 6.00

D4091-1 Manufactured No
Mounting Lug

100 Each 24.0000

1

6

Location

Loc Qty

Loc Code

ST458

24

81005

24

3

12

D4149-1 Manufactured No
Crosstube Lug Plate, Aft

100 Each 22.0000

2

12

Location

Loc Qty

Loc Code

ST133

22

78044

7

81008

15

3

6

D4149-3 Manufactured No
Spacer

100 Each 29.0000

1

6

Location

Loc Qty

Loc Code

ST133

29

78046

29

6

6

D4149-5 Manufactured No
Eyebolt Stud

100 Each 16.0000

1

6

Location

Loc Qty

Loc Code

ST133

16

79057

16

6

12

AN3C12A Purchased No
Bolts

100 Each 324.0000

2

12

Location

Loc Qty

Loc Code

GA

50

120449

50

ST351

274

117514

4

118112

5

118451

22

119510

1

120423

242

12

Wednesday, March 14, 2012 2:25:05 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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Picklist Print

Wednesday, March 14, 2012 2:25:05 PM

Page 3

Work Order ID: 81472

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 3/14/2012

Required Date: 4/6/2012

Start Qty: 6.00

Required Qty: 6.00

AN4C13A Purchased No

100 Each 130.0000

3 18

BOLT

Location

Loc Qty

Loc Code

ST357

130

120187

1

120423

129

MS20615-4M18

Purchased No

100 Each 314.0000

3 18

Rivet

Location

Loc Qty

Loc Code

ST323

314

118077

150

118543

164

NAS1149C0332R

Purchased No

100 Each 3,597.0000

4 24

Washer

Location

Loc Qty

Loc Code

ST297

3597

118354

551

119736

196

120648

2850

NAS1149C0432R

Purchased No

100 Each 2,618.0000

6 36

Washer

Location

Loc Qty

Loc Code

ST297

2618

117291

1618

119124

1000

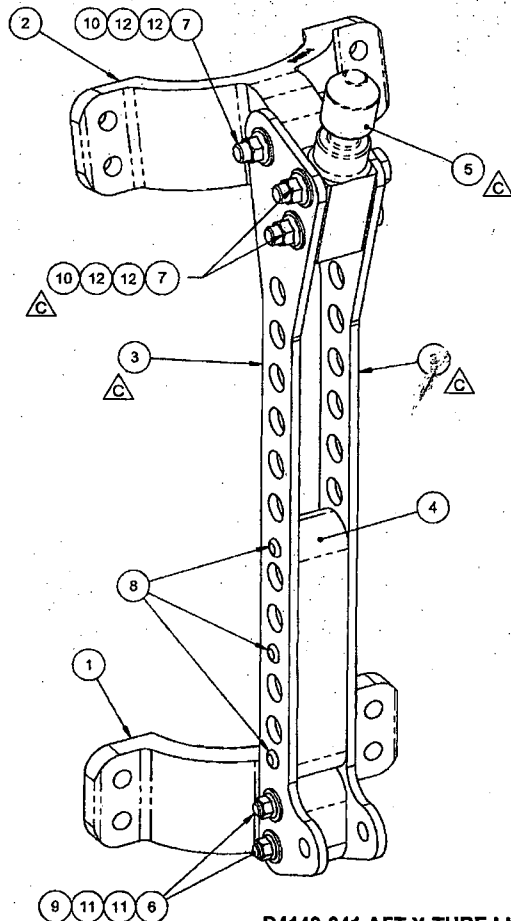
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20815-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

81470

RELEASED
2011-02-24

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20815-4M18 WAS MS20815-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3910-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20815-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-907-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.08.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

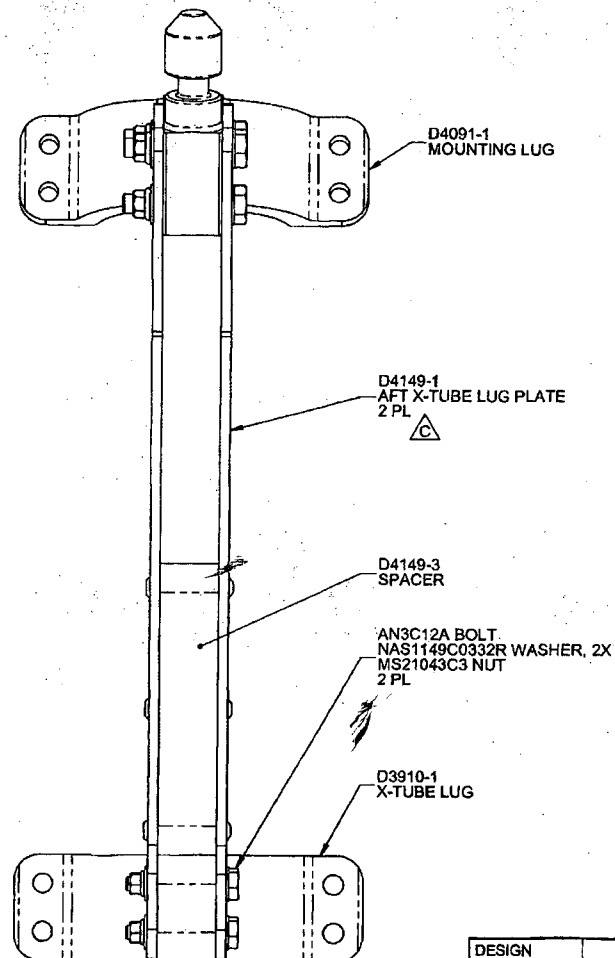
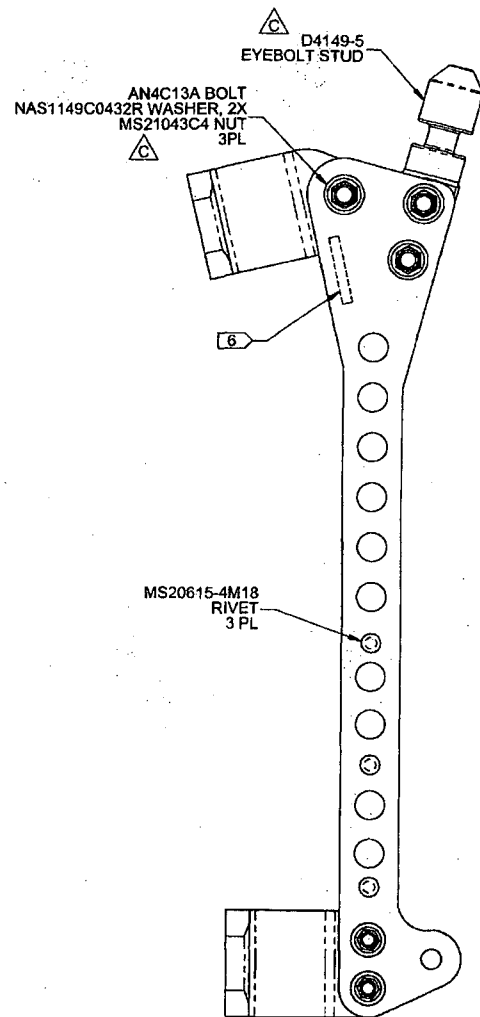
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NOTE: Date & initial all entries




8 7 6 5 4 3 2 1



#81472

RELEASED
2011-02-24
MP

D4149-041 AFT X-TUBE LUG ASSY

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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8 7 6 5 4 3 2 1

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Dart Aerospace Ltd

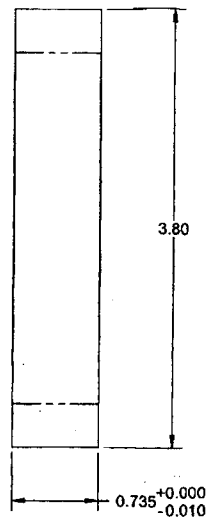
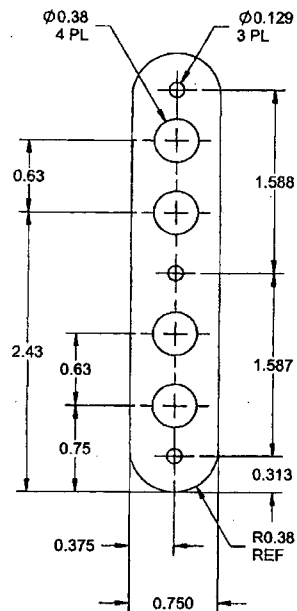
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

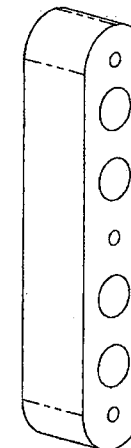
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries




D4149-3 SPACER



#81472

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB		DART AEROSPACE LTD	
DRAWN	SC		HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. C
MFG. APPR.			D4149	SHEET 4 OF 5
APPROVED			TITLE	SCALE
DE APPR.			AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD		
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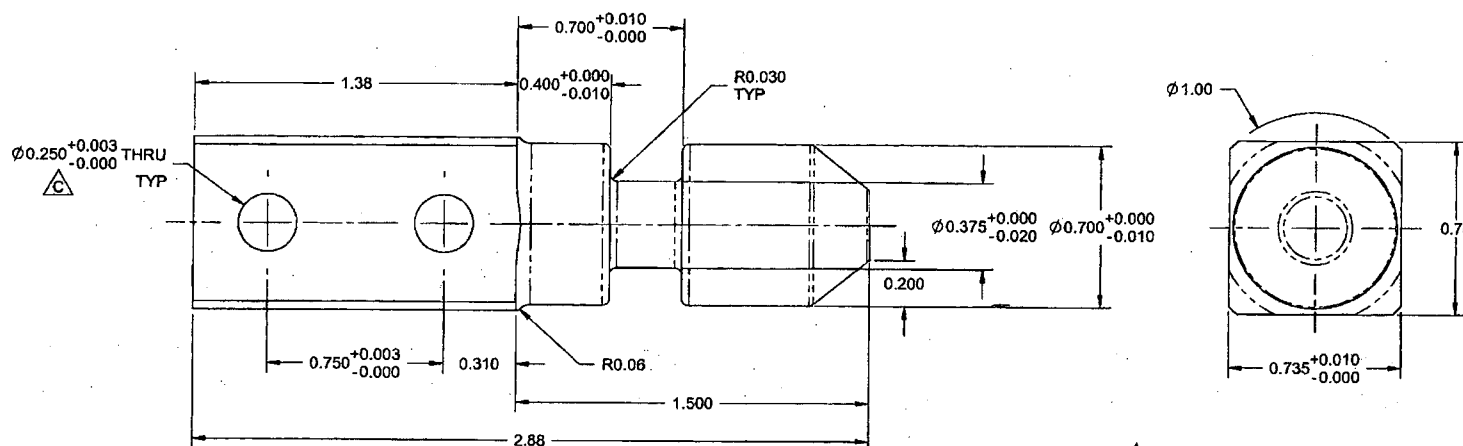
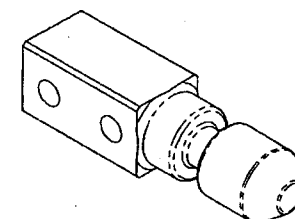
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NOTE: Date & initial all entries



D4149-5 EYEBOLT STUD

#81470

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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